

## Page 1

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**Reference:**

Stop \*NR2\*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84318

**\*84318\***

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Item ID: D3350-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Strut Assembly  
 Start Date: 09/05/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 23/05/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		29 12-5-15		4	4		
140 <b>*140*</b> Small Fab Small Fab	Small Fab  Memo Tumble and Deburr	0.00  0.00		N/A					
150 <b>*150*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				4	26	12-5-17	

W/O:		WORK ORDER CHANGES					
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# Work Order ID 84318

**\*84318\***

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 Item Name: Strut Assembly  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> Powdercoat Powder Coating  W121841	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel  Memo START TIME: 11:20 FINISH TIME: 11:50 OVEN TEMPERATURE: 320°F	0.00 0.00				4X	Ø		M/L 12/07/03
200 <b>*200*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				4	Ø	Ø/B	12/07/03
210 <b>*210*</b> Packaging Packaging	Identify as per dwg & Stock Location: 5271  Memo	0.00 0.00				4X		SP	12-7-3

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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**Work Order ID 84318****\*84318\***

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May-09-12 1:46:01 PM

Item ID: D3350-041      Accept      **\*N900040100\***      Setup      Start      **\*NS1\***  
Revision ID:      Stop      **\*NS2\***  
Item Name: Strut Assembly  
Start Date: 09/05/2012      Start Qty: 4.00      **\*4\***      Cust Item ID:  
Required Date: 23/05/2012      Req'd Qty: 4.00      **\*4\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start      **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop      **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

12/17/4 *[Signature]*  
ME  
12-07-03

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

## Picklist Print

May-09-12 1:46:04 PM

Page 1

Work Order ID: 84318

\*84318\*

Parent Item: D3350-041

\*D3350-041\*

Parent Item Name: Strut Assembly

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B05.07.11 Powder Coat now done after assembly KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21042L3

Purchased

No

110

Each

2,926.000

2

8

\*MS21042L3\*

Nut

\*\*

(4)

FF 12-05-17

## Location

## Loc Qty

## Loc Code

ST300

2926

117885

32

119017

1117

119075

138

121349

656

121444

983

AN3-12A

Purchased

No

170

Each

22.0000

2

8

\*AN3-12A\*

Bolt

\*\*

(4)

FF 12-05-17

## Location

## Loc Qty

## Loc Code

ST351

22

114536

1

119641

21

AN960JD10

NAS1149D0363J

Purchased

No

170

Each

0.0000

4

16

\*AN960JD10\*

Washer

D2324-5

Manufactured , No

\*D2324-5\*

Strap

\*\*

(4)

FF 12-05-17

\*\*

(4)

FF 12-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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May-09-12 1:46:05 PM

Page 2

Work Order ID: 84318

\*84318\*

Parent Item: D3350-041

\*D3350-041\*

Parent Item Name: Strut Assembly

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

M6061T6B0.750X00.75  
0

Purchased No

170 f

11.2300 1.2604 5.306947

\*M6061T6B0 750X00 750\*

\*\*

6061-T6 Bar .750 x .750

Location

Loc Qty

Loc Code

MAT002

8.58

114993

4.58

119346

4

MAT003

2.65

119801

2.65

5.307 *mk 12/05/15*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

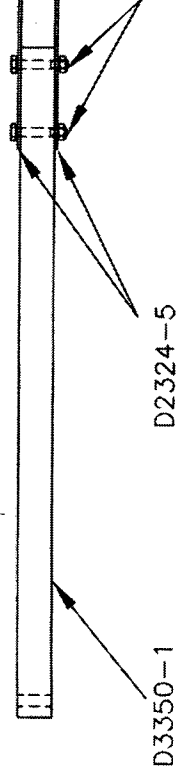
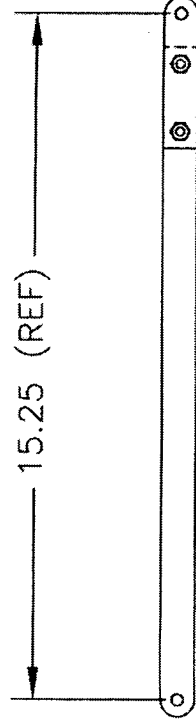
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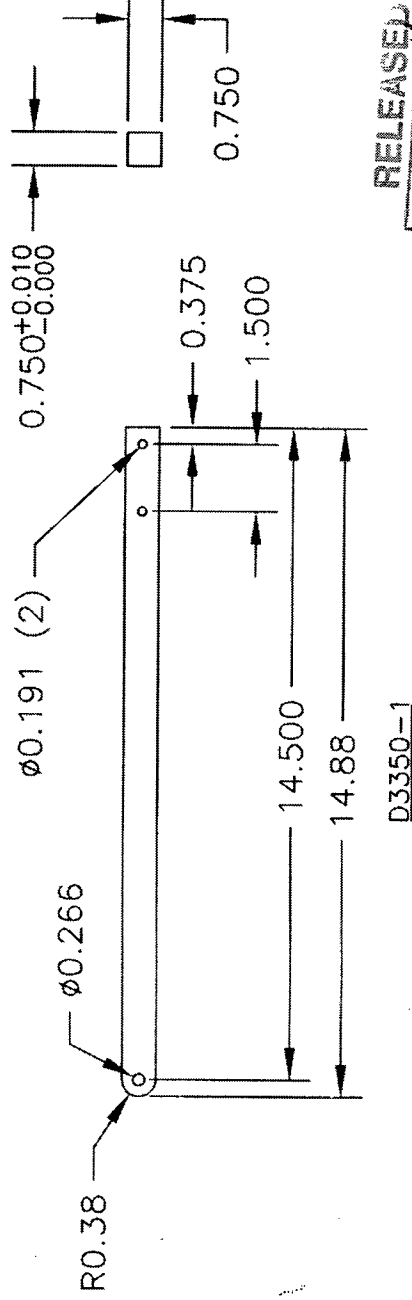
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CH	APPROVED H	DRAWING NO. D3350
DATE 04.11.12		REV. A SHEET 1 OF 1
		SCALE 1:4
		TITLE STRUT
A	04.11.12	NEW ISSUE



AN3-12A BOLT (1)  
AN960JD10 WASHER (2)  
MS21042L3 NUT (1)  
(TYP 2 PLACES)

#### D3350-041 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D3350-041 USING FINE POINT PERMANENT INK MARKER



#### D3350-1

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

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